

# Work Order ID 62496

Thursday, September 30, 2010 1:49:40 PM



Page 1

Item ID: PB67-43001-27

Accept



Setup Start



Revision ID:

Item Name: Blade Positioner

Stop



Start Date: 10/1/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: mf

Date: 10-9-30 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr     | Revision Nbr |
|--------------|--------------|
| B67-43001-27 | Rev C        |

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- slide -289, -291 and -293 on -19 tube then slide it in -285 tube □2- drill holes  
0.159 (#21) thru -285 into -289 in (3) place and tap 10-32 UNF as per dwg □3-  
assemble all parts as per dwg PB67-43001

10-10-13 1 [Signature]

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

10-10-14

[Signature]

120

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

PP 63058

10/10/2014

[Signature]

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**Work Order ID 62496**

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Item ID: PB67-43001-27

Accept



Setup Start



Revision ID:

Stop



Item Name: Blade Positioner

Start Date: 10/1/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/20

MF

10-10-20

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 62496

Parent Item: PB67-43001-27

Parent Item Name: Blade Positioner






Start Date: 10/1/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-07-29 new issue DD verified by:ec  
IPP Rev:B 08-12-04 up date part list DD Verified by:ec IPP Rev  
C 10.09.28 per rev C dwg EC verified by:DD

| Component Item ID/<br>Item Name  | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID   | Unit of<br>Measure | Qty on<br>Hand  | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-------------------|--------------------|-----------------|-------------|--------------|---------------|----------------|--------|
| PB67-43001-19<br><br>Inner Tube and Retainer Bushing         |                        | Manufactured  | No          |                     |                  | 100               | Each               | 1.0000          | 1           | 1            |               | 10.10.13       |        |
|  |                        |               |             | <u>Location</u>     |                  | <u>Loc Qty</u>    |                    | <u>Loc Code</u> |             |              |               |                |        |
|  |                        |               |             | ST                  |                  | 1                 |                    |                 |             |              |               |                |        |
|  |                        |               |             | 62114               |                  | 1                 |                    |                 |             |              |               |                |        |
| PB67-43001-29<br><br>Blade Positioner Weldment               |                        | Manufactured  | No          |                     |                  | 100               | Each               | 0.0000          | 1           | 1            |               | 10.10.13       |        |
|  |                        |               |             | 362118              |                  | <del>345032</del> |                    |                 |             |              |               |                |        |
| *PB67-43001-31<br><br>PB67-43001-31 Upper Restraint Weldment |                        | Manufactured  | No          |                     |                  | 100               | Each               | 0.0000          | 1           | 1            |               | 10.10.13       |        |
|  |                        |               |             |                     |                  | 353335            |                    |                 |             |              |               |                |        |
| PB67-43001-35<br><br>PB67-43001-35 Lower Pad Assembly      |                        | Manufactured  | No          |                     |                  | 100               | Each               | 6.0000          | 1           | 1            |               | 10.10.13       |        |
|  |                        |               |             | <u>Location</u>     |                  | <u>Loc Qty</u>    |                    | <u>Loc Code</u> |             |              |               |                |        |
|  |                        |               |             | ST443               |                  | 6                 |                    |                 |             |              |               |                |        |
|  |                        |               |             | 45030               |                  | 6                 |                    |                 |             |              |               |                |        |
| PB67-43001-285<br><br>Upper Tube, Blade Positioner         |                        | Manufactured  | No          |                     |                  | 100               | Each               | 1.0000          | 1           | 1            |               | 10.10.13       |        |
|  |                        |               |             | <u>Location</u>     |                  | <u>Loc Qty</u>    |                    | <u>Loc Code</u> |             |              |               |                |        |
|  |                        |               |             | ST446               |                  | 1                 |                    |                 |             |              |               |                |        |
|  |                        |               |             | 52670               |                  | 1                 |                    |                 |             |              |               |                |        |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 62496



Parent Item: PB67-43001-27



Parent Item Name: Blade Positioner

Start Date: 10/1/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

PB67-43001-289 Manufactured No

100

Each

5.0000

1

1



Stationary Handle Adjustment Fitting



10-10-13

LocationLoc QtyLoc Code

ST439

5

62117

5

PB67-43001-291 Manufactured No

100

Each

4.0000

1

1



Clamp Bushing



10-10-13

LocationLoc QtyLoc Code

ST439A

4

62121

4

PB67-43001-293 Manufactured No

100

Each

14.0000

1

1



Extension Tube Adjustment Fitting



10-10-13

LocationLoc QtyLoc Code

ST439A

14

41882

7

47365

7

AN6-22A Purchased No

100

Each

27.0000

1

1



BOLT



10-10-13

LocationLoc QtyLoc Code

ST342

27

110155

7

111060

20

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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



# Picklist Print

Thursday, September 30, 2010 1:49:40 PM

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Work Order ID: 62496

Parent Item: PB67-43001-27

Parent Item Name: Blade Positioner

Start Date: 10/1/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

MS21042L6

Purchased

No

100

Each

256.0000

1

1



Nut



*10.10.13*

Location

Loc Qty

Loc Code

ST300

256

111578

4

114495

52

115300

200

MS27039-1-04

Purchased

No

100

Each

353.0000

3

3



SCREW



*10.10.13*

Location

Loc Qty

Loc Code

ST291

353

115006

353

MS27039-1-08

Purchased

No

100

Each

1,589.000

1

1



Screw



*10.10.13*

Location

Loc Qty

Loc Code

ST291

1589

110835

477

114718

112

115108

1000

MS27039-1-09

Purchased

No

100

Each

385.0000

6

6



Screw



*10.10.13*

Location

Loc Qty

Loc Code

ST291

385

111650

356

18057

29

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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, September 30, 2010 1:49:40 PM

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Work Order ID: 62496

Parent Item: PB67-43001-27



Parent Item Name: Blade Positioner

Start Date: 10/1/2010

Required Date: 10/15/2010



Start Qty: 1.00

Required Qty: 1.00

MS51859-8 Purchased No 100 Each 63.0000 2 2  
  
 WASHER  10.10.13



Location Loc Qty Loc Code

ST296 63  
112940 63

NAS1149F0316P Purchased No 100 Each 287.0000 7 7  
  
 WASHER  10.10.13



Location Loc Qty Loc Code

ST275 287  
112940 87  
 113237 100  
 113644 100

NAS1149F0363P Purchased No 100 Each 169.0000 3 3  
  
 Washer  10.10.13

Location Loc Qty Loc Code

ST275 169  
113254 69  
 114382 100

NAS1149F0632P Purchased No 100 Each 481.0000 2 2  
  
 WASHER  10.10.13

Location Loc Qty Loc Code

ST275 481  
18057 481

Thursday, September 30, 2010 1:49:40 PM

Shop Packet Print

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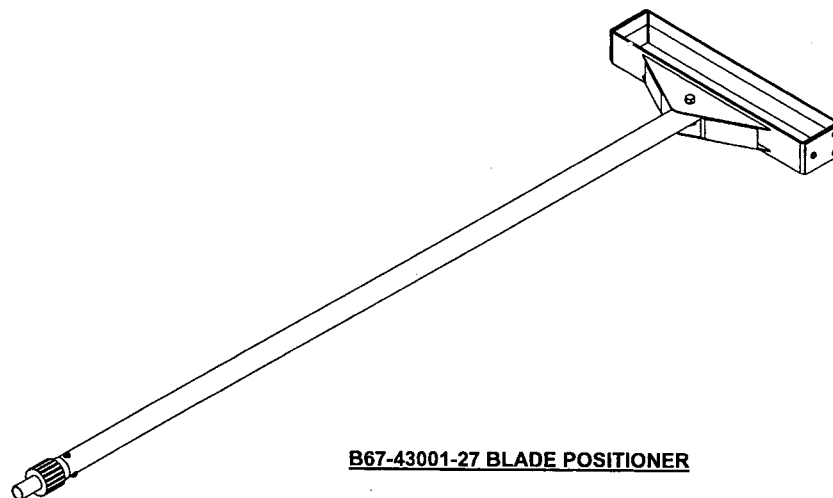
| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



**B67-43001-27 BLADE POSITIONER**

#62496

**NOTES:**

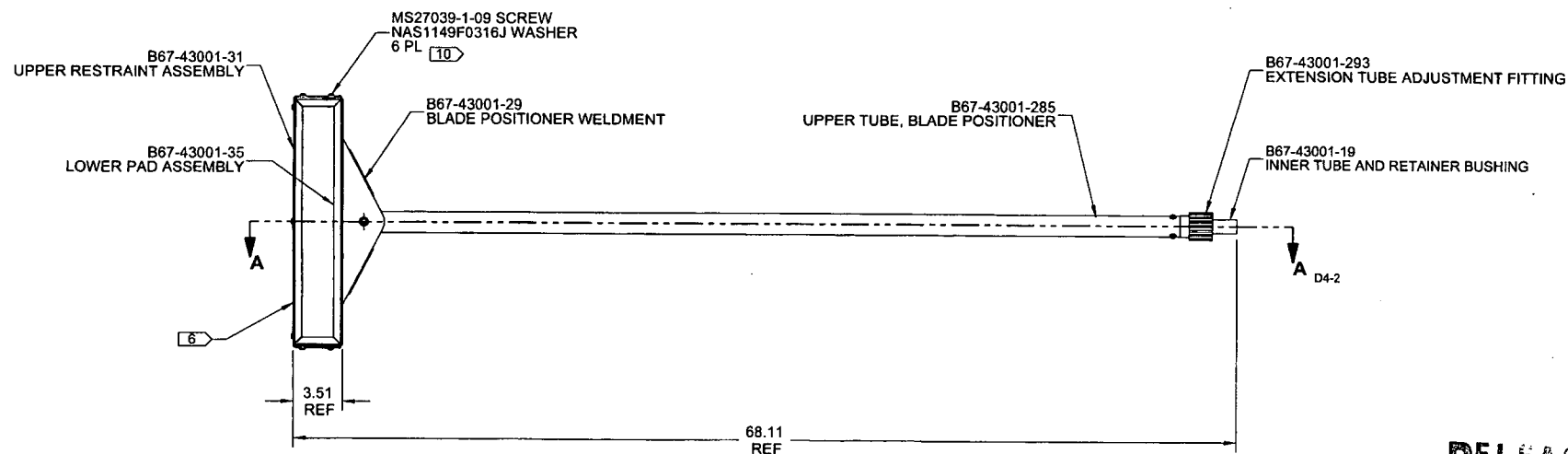
- 1) MATERIAL: NONE
- 2) FINISH: TOUCH UP PAINT WITH SANDFLEX GREEN.  
POSSIBLE SUPPLIER BERTRAND BODY SHOP SUPPLIES P/N DART01K
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH RED LABEL
- 7) WEIGHT: 7.07 lbs
- 8) DRILL THRU B67-43001-285/-289 PRIOR TO ASSEMBLY
- 9) DO NOT TORQUE NUT ON BOLT: TIGHTEN UNTIL SNUG
- 10) MATCH DRILL  $\varnothing 0.193$  HOLE THRU B67-43001-29 WITH NUTPLATES LOCATED ON B67-43001-35

| ITEM | QTY.<br>-27 | P/N           | DESCRIPTION                          |
|------|-------------|---------------|--------------------------------------|
|      | X           | B67-43001-27  | BLADE POSITIONER                     |
| 1    | 1           | B67-43001-19  | INNER TUBE AND RETAINER BUSHING      |
| 2    | 1           | B67-43001-29  | BLADE POSITIONER WELDMENT            |
| 3    | 1           | B67-43001-31  | UPPER RESTRAINT ASSEMBLY             |
| 4    | 1           | B67-43001-35  | LOWER PAD ASSEMBLY                   |
| 5    | 1           | B67-43001-285 | UPPER TUBE, BLADE POSITIONER         |
| 6    | 1           | B67-43001-289 | STATIONARY HANDLE ADJUSTMENT FITTING |
| 7    | 1           | B67-43001-291 | CLAMP BUSHING                        |
| 8    | 1           | B67-43001-293 | EXTENSION TUBE ADJUSTMENT FITTING    |
| 9    | 1           | AN6-22A       | BOLT                                 |
| 10   | 1           | MS21042L6     | NUT                                  |
| 11   | 3           | MS27039-1-04  | SCREW                                |
| 12   | 1           | MS27039-1-08  | SCREW                                |
| 13   | 6           | MS27039-1-09  | SCREW                                |
| 14   | 2           | MS51859-8     | WASHER                               |
| 15   | 7           | NAS1149F0316P | WASHER                               |
| 16   | 3           | NAS1149F0363P | WASHER                               |
| 17   | 2           | NAS1149F0632P | WASHER                               |

**RELEASED**  
2010-09-21  
AM

|            |          |   |              |      |          |
|------------|----------|---|--------------|------|----------|
| C          |          | REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043, FOR PREVIOUS REVISIONS, REFER TO SHEET 4 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.  |              | VS   | 10.06.10 |
| REV.       |          | DESCRIPTION   | BY           | DATE |          |
| DESIGN     | RW       | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA  |              |      |          |
| DRAWN      | VS       |   |              |      |          |
| CHECKED    |          | DRAWING NO.   | REV. C       |      |          |
| MFG. APPR. |          | B67-43001-27  | SHEET 1 OF 3 |      |          |
| APPROVED   |          | TITLE   | SCALE        |      |          |
| DE APPR.   |          | BLADE POSITIONER  | NTS          |      |          |
| DATE       | 10.06.10 | <small>COPYRIGHT © 1995 BY DART AEROSPACE LTD<br/>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> |              |      |          |

**SECTION A-A B2-2**

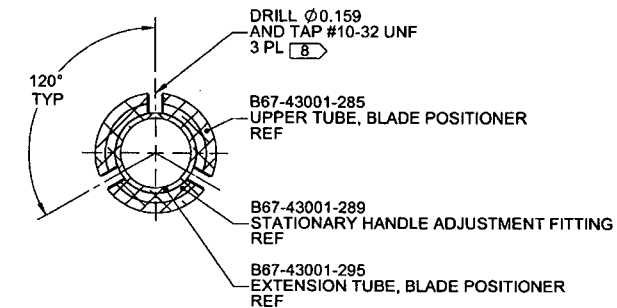


**B67-43001-27 BLADE POSITIONER**

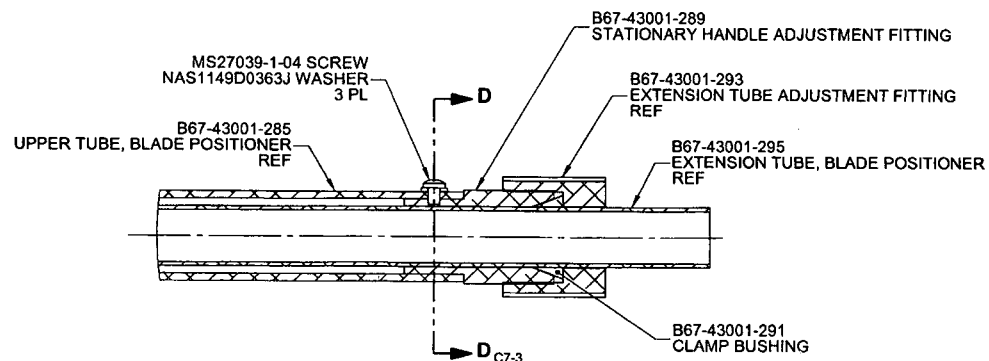
**RELEASED**  
2010-09-21

#62496

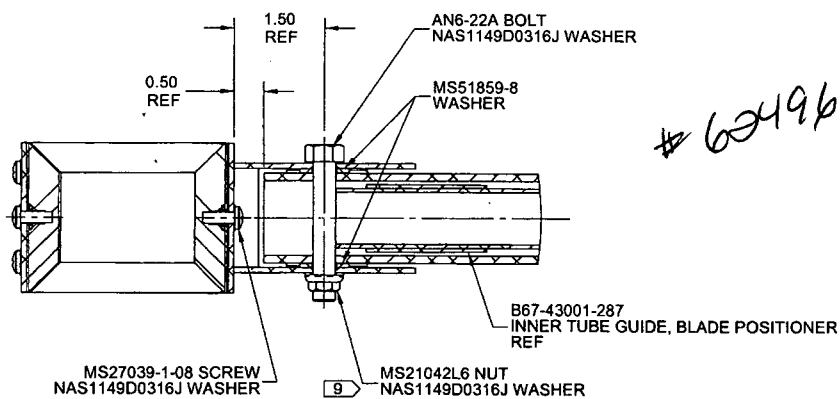
|            |          |  |              |
|------------|----------|--|--------------|
| DESIGN     | RW       | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA   |              |
| DRAWN      | VS       |  |              |
| CHECKED    |          | DRAWING NO.  | REV. C       |
| MFG. APPR. |          | <b>B67-43001-27</b>  | SHEET 2 OF 3 |
| APPROVED   |          | TITLE  | SCALE        |
| DE APPR.   | N/A      | <b>BLADE POSITIONER</b>  | NTS          |
| DATE       | 10.06.10 | <small>COPYRIGHT © 1995 BY DART AEROSPACE LTD<br/>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> |              |



**SECTION D-D** C3-3  
(HARDWARE NOT SHOWN FOR CLARITY)







**DETAIL C** D3-2  
SCALE 4X



**DETAIL B** D7-2  
SCALE 4X

#62496

**RELEASED**  
2010-09-21

|            |   |  |              |
|------------|---|--|--------------|
| DESIGN     | RW  | <b>DART AEROSPACE LTD</b>  |              |
| DRAWN      | VS  | HAWKESBURY, ONTARIO, CANADA  |              |
| CHECKED    |  | DRAWING NO.  | REV. C       |
| MFG. APPR. |  | <b>B67-43001-27</b>  | SHEET 3 OF 3 |
| APPROVED   |  | TITLE  | SCALE        |
| DE APPR.   |  | <b>BLADE POSITIONER</b>  | NTS          |
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